

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001644**Date Inspected:** 30-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Mock-Ups and OBG Components**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector,(QA),M. Paul Stovall, was present at Zhenhua Port Machinery Company, (Z. P. M. C.), on Changxing Island, Shanghai, China for the purpose of monitoring the fabrication of the SAS/San Francisco/Oakland Bay Bridge.

89-meter Mock-Up, Z. P. M. C., Welder Han Xiaofeng—054467, and Dai Lu—048659, are welding weld numbers MUB-MA21-G/J-71, and MUB-MA21-A/J-(62 and 63). Upon arrival QC Certified Welding Inspector (CWI), Xu Le Feng, pointed out to the QA Inspector cracked tack welds. The QA Inspector called QC Inspector Lei Tao, and asked him to speak with the CWI, in regards to what was going to be done with the cracked tacks. Initially the QA Inspector was told that Z. P. M. C. would grind and Magnetic Particle Test (MT) the ground welds. Later on Z. P. M. C. decided to completely remove the cracked tack welds and reweld them. This was confirmed.

(Bay 1), Z. P. M. C. personnel milled the edges of stacked, unbent U Ribs, that are slotted and drilled on one end. Z. P. M. C. personnel were cleaning burrs from edges of beveled U ribs.

**Summary of Conversations:**

The QA Inspector had no substantial conversations.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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## WELDING INSPECTION REPORT

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<b>Inspected By:</b>	Stovall,Paul	Quality Assurance Inspector
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<b>Reviewed By:</b>	Cochran,Jim	QA Reviewer
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